Quality Control

DQA:		1	Date:			•							79	
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / UP		Work Order	update only		AEROSPACE
						DISPOSITION					****			
Work Orde	er: _					DISPOSITION				AGAINST L	PEPAKTIVIEN	T/PROCESS		
						Rework			Skid-tube	Crosstube		Water Jet		Engineering
Part N	No					Scrap		!	Machining	Small Fab	Pı	od. Eng. Coor.		Quality
NCR 1	No					Use-as-is Suspected Unapproved	,	Thern	noforming Large Fab	Finishing Composite	Rec/St	ore/Packaging Supplier	-	Other
Root		٠,	-		Desc	ription of work order update	ı	Initial	Actio	on	Sign &		\Box	
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descrip	ption	Date	Verification	n ·	QC Inspector
Design														
Doc/Data				,		•								
Equip/Tooling	Ш	5		-									l	
Handling/Pre	Ц		٠				ŀ			•				
Material	Ш					. ĉ							Ī	
Operator	Ш					•								
Offset/Setup	Ш								`					
Process	Ш													
Supplier										•				
Training														•
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Unapproved			-											
							FAI	ULT CAT	TEGORY	·				
Landi					_	General		1		_	_	,	$\overline{}$	
	\vdash	Bending			<u> </u>	Bend	_	1	rogram	<u> </u>	Outside Di	i	—	Pressure/Forced
	\vdash	Centre No	t Concer	ntric	-	BOM/Route	<u> </u>	Grain		 -		r tolerance		Set-up
	—	Cracks			<u> </u>	Broken/Damage/Defect	_	Hardwa	* .		Part Incorr		-1	Temperature/Cure
	-	Crimp/Kin	ik/Ripple	/Wave	-	Burrs	-	1	on Incomplete/Und	· -	Part Lost/	٠ ا	—	Weld
	\vdash	Cuffs			-	Contamination		1	ions Incomplete/Ur	nclear	Part Move		ٰلٰـــٰ	Wrong Stock Pulled
	\vdash	Crushing			<u> </u>	Countersink	-	-	ned/off center	ļ.	Positioned	_		
	-	Heat Trea			-	Cut Too Short	├ ─	Mislabe		Ŀ	Power Los	s/Surge	<u></u>	Other
	\vdash	nspection		Tube	\vdash	Drawing		Misread	i					
).	Н	Marks/Ch			-	Drill Holes	<u> </u>	Off-set						
~~.	_	Turning So Wave/Twi			<u> </u>	Finish		4	Calibration					
· "	1 18 1	Mave/Twi	ist in Triĥ	څد	1	Fit/Function	1	IOut of 9	Contience					

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Ord		04338		*104	1338*					THE PERSON AND THE PE	Page 2	_
Item ID: Revision ID:	D2278			Accept	*N900	040	100)* s	etup Start	I VI	S1* S2*	
Item Name: Start Date: Required Date Reference:	7/09/13: 7/09/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	ID:			·	· Ni		
Approvals:	Process P	Plan:		Tooling: SPC (Y/N):		ate:	-	R	un Star Stop		R1* R2*	
Sequence ID/ Work Center I 130 *120* HandFinish Hand Finishing	D	Operation Description Chemical Conversion C	oat per QSI005 4.1	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
140 *14 *1 QC Quality Control		QC3 Inspect Part Finis Memo	h	0.00		30)	_6_			3/09	(30
150 *150*		Identify as per dwg & S	tock Location:	0.00	··			<u>(</u>			St13	Joal

0.00

Memo

Packaging

Packaging

DQA: 🔹			Date:						_				-34	
OA Clasadi			Date:			WORK ORDER NON	-C(ONFO	RMANCE / UP		Indi Ondon	ا برامه معادد آ	_	AEROSPACE
QA Closed:			Date.		-		-	I	· · · · · · · · · · · · · · · · · · ·	V	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST DI	EPARTMENT,	/PROCESS		
	_					Rework]		Skid-tube	Crosstube	7	Water Jet		Engineering
Part N	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.		Quality
	_					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	\neg	Other
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Root	- 1				Desci	ription of work order update		Initial	Actio		Sign &			
Cause		Date	Step	Qty		or non-conformance	Cr	ief Eng	Descri	ption	Date	Verification	1	QC Inspector
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Offset/Setup Process	Н													
Supplier	Н													
Training	Н													
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	Шв	ending				Bend		Folio/P	rogram		Outside Dim	ensions	F	Pressure/Forced
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		racks				Broken/Damage/Defect		Hardwa	re		Part Incorred	ct [1	Temperature/Cure
	Щc	rimp/Kir	ık/Ripple,	/Wave		Burrs		Inspecti	ion Incomplete/Und	qualified	Part Lost/Mi	ssing	\	Weld
	$\boldsymbol{\vdash}$	uffs				Contamination		Instruct	ions Incomplete/Ur	nclear	Part Moved	Į	\	Wrong Stock Pulled
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•	——		n Strip in	Tube		Drawing	_	Misread	d					
	-	/larks/Ch				Drill Holes	_	Off-set						
!	_	_	equence		_ ⊢	Finish		1	Calibration			·		
	ΙİV	Vave/Tw	ist in Tub	e		Fit/Function	1	Dut of 9	Sequence					

Work Order ID 104338 *104338* Page 3 July-09-13 12:29:18 PM *N900040100* Accept Setup Start Item ID: D2278 **Revision ID:** Item Name: Step Leg 7/09/13 Start Qty: 6.00 **Cust Item ID: Start Date:** Required Date: 7/09/13 **Req'd Qty:** 6.00 **Customer:** Reference: Run Tooling: Date: Date: Approvals: Process Plan: Stop SPC (Y/N): Date: QC: Date: Reject Reject Tool ID Tool # Plan Accept Insp. Sequence ID/ Operation Set Up/ Number Stamp Code **Qty** /Qty Work Center ID Description **Run Hours** 13/09/30 0.00 160 QC21- Final Inspection - Work Order Release *160* 0.00 QC Memo Quality Control

MF 13-9-3U

DQA:			Date:			WORK ORDER NON-	.c	ONEOI	RMANCE / III	DDATE			DART
QA Closed:			Date:						WINIAITEL / OI		Vork Order up	odate only	AEROSPACE
Work Orde						DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Part N	- lo					Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Desci	ription of work order update	ı	Initial	Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved							501						
Landie							FA	ULT CAT	EGURY				···
Landii		Bending Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspection Marks/Ch Furning Si	k/Ripple t n Strip in atter	/Wave		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misreac Off-set	on Incomplete/Un ions Incomplete/U ned/off center led	· -	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	_	Nave/Tw		ne		Fit/Function	-	ł	equence				
		vave/ i W	ist iii TUD	T		i ity i unction		Tour or s	equence				

Picklist Print

July-09-13 12:29:18 PM

Work Order ID:

104338

Parent Item:

D2278

Parent Item Name:

Component Item ID/

Step Leg

Start Date: 7/09/13

Required Date: 7/09/13

Start Qty: 6.00

Required Qty: 6.00

Comments:

Item Name

IPP Rev:A

05-11-07 New Issue

JLM JLM

IPP Rev:B IPP Rev C

Item ID

Replacement

Now 6061-T6 '06-06-23 New flat pattern 08.01.11 EC

Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date
C ID	Maggura	Hand		O4	hansel	Icene

M6061T6S.080.

Purch Purchased

Mfg/

No

Bin

Item

Primary Location Location

Last

Seq ID

100

Measure Hand

Qty

Issued

Status

Issued

sf

239.4900

0.9815

6061-T6 .080 Sheet

Location

Loc Qty 239.49

Loc Code

125812

MAT021

m125812

239.49

DQA:		Date:					ON FO	DA A A I CE / 111	DATE			
QA Closed:		Date:			WORK ORDER NON-	-C(JNFO	RIMANCE / UI		Vork Order uj	odate only	AEROSPACE
					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Work Orde	er:				, _, ,					7		1
Dort N	do.				Rework			Skid-tube	Crosstube Small Fab		Water Jet	Engineering
Part N	NO				Scrap Use-as-is			Machining noforming	Finishing		d. Eng. Coor. re/Packaging	Quality Other
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110111					Suspected Onapproved	l		Earge rab	composite	J	Supplie!	┛ ┗┛
Root				Desc	ription of work order update		nitial	Act	ion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
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Handling/Pre												
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Operator												
Offset/Setup												
Process												·
Supplier				• •								
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Unapproved	<u> </u>		<u> </u>	<u> </u>								
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Landi	ng Gear				General		1		_	٦	. –	7
	Bendir	_		-	Bend BONA (Books	<u> </u>	1	Program	· -	Outside Dim	—	Pressure/Forced
		Not Conce	ntric	<u> </u>	BOM/Route		Grain		<u> </u> -	Over/Under	 	Set-up
	Cracks		- /\41	-	Broken/Damage/Defect		Hardwa		_	Part Incorre	 	Temperature/Cure
		Kink/Ripple	e/wave	` -	Burrs		1	ion Incomplete/Un	· -	Part Lost/Mi	ssing	Weld
	Cuffs			\vdash	Contamination		•	ions Incomplete/U	Inclear	Part Moved	<u>L</u>	Wrong Stock Pulled
	Crushi			-	Countersink		1 -	gned/off center	-	Positioned V		Joseph 2 12
	Heat T		Tuba	<u> </u>	Cut Too Short	—	Mislabe			Power Loss/	Surge	Other
	⊢	tion Strip in /Chatter	eauri	\vdash	Drawing Drill Holes	\vdash	Misread	ג			·	
,	⊢			-	Finish	\vdash	Off-set	Calibration				
j.		g Sequence Twist in Tul		<u> </u>	Fit/Function	\vdash	i	Calibration Sequence				
	i ivvave/	I WISLIII IU	NC	1	(FIGE WILLIAM)		TOUL OF 3	JEGUETICE				

DART AEROSPACE LTD	Work Order:	104338
Description: Leg	Part Number:	D2278
Inspection Dwg: D2278 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X Firs	st Article	Pro	ototype
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Drawing		Actual	_		Method of	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
0.354	+/-0.010	0.359	`		U	James
0.354	+/-0.010	0.358	_		V	
16.46	+/-0.030	(6.46"	_		T	JAMOG
Ø0.128	+0.005/-0.000	0.139"	_		V	
R0.354	+/-0.030	0354"			N RG	
2.00	+/-0.030	3.∞7.	-		V	
4.74	+/-0.030	4.746	_		V	
8.46	+/-0.030	8.475	•		V	Predutor
0.213	+/-0.010	0.219"	-		V	77-20-60-6
0.750	+/-0.010	O.776"			V	
0.080 thick	+/-0.010	<u>০ ৩৪৫ </u>			V	W W
						1100
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			DAS			!

		27		
Measured by:	Audited by:	9-89	Prototype Approval:	N/A
Date: 13-09-27	Date:	13 930	Date:	N/A

Revised by KJ/JLM	Approved
KJ/JLM	
	1/2
_	KJ/JLM KJ/JLM KJ/DD

